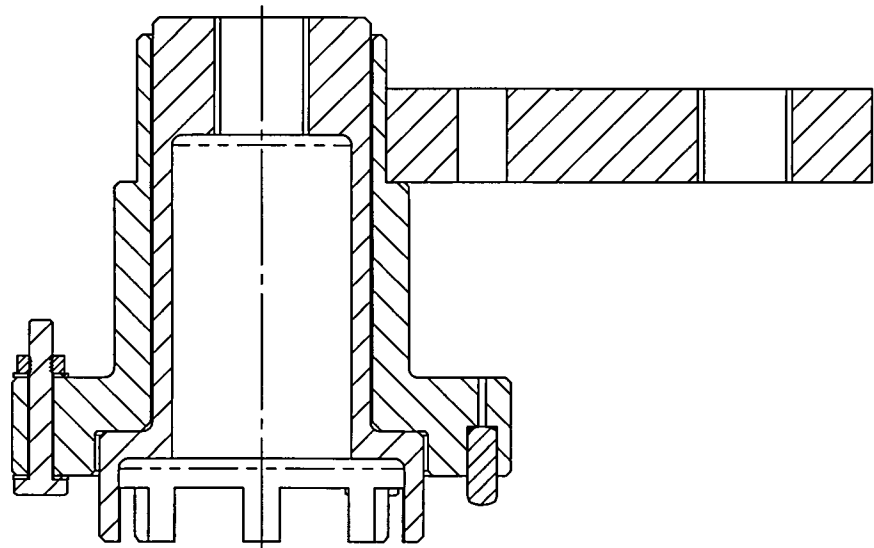
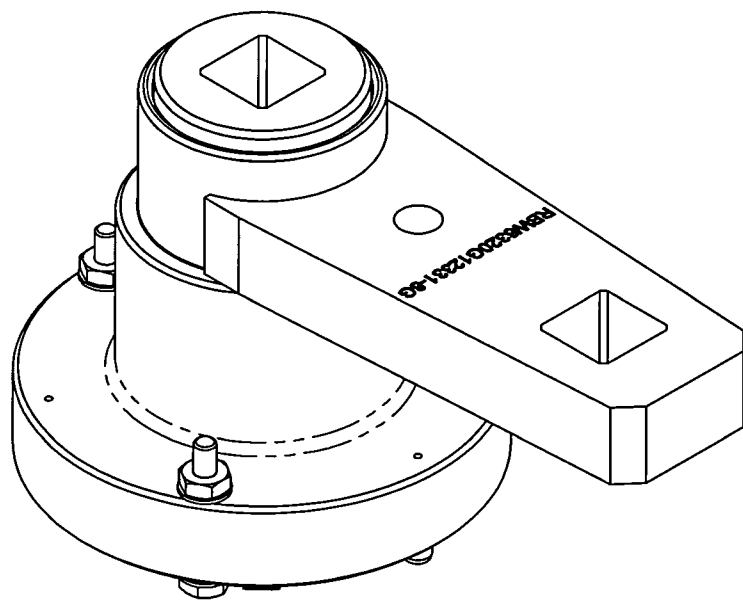
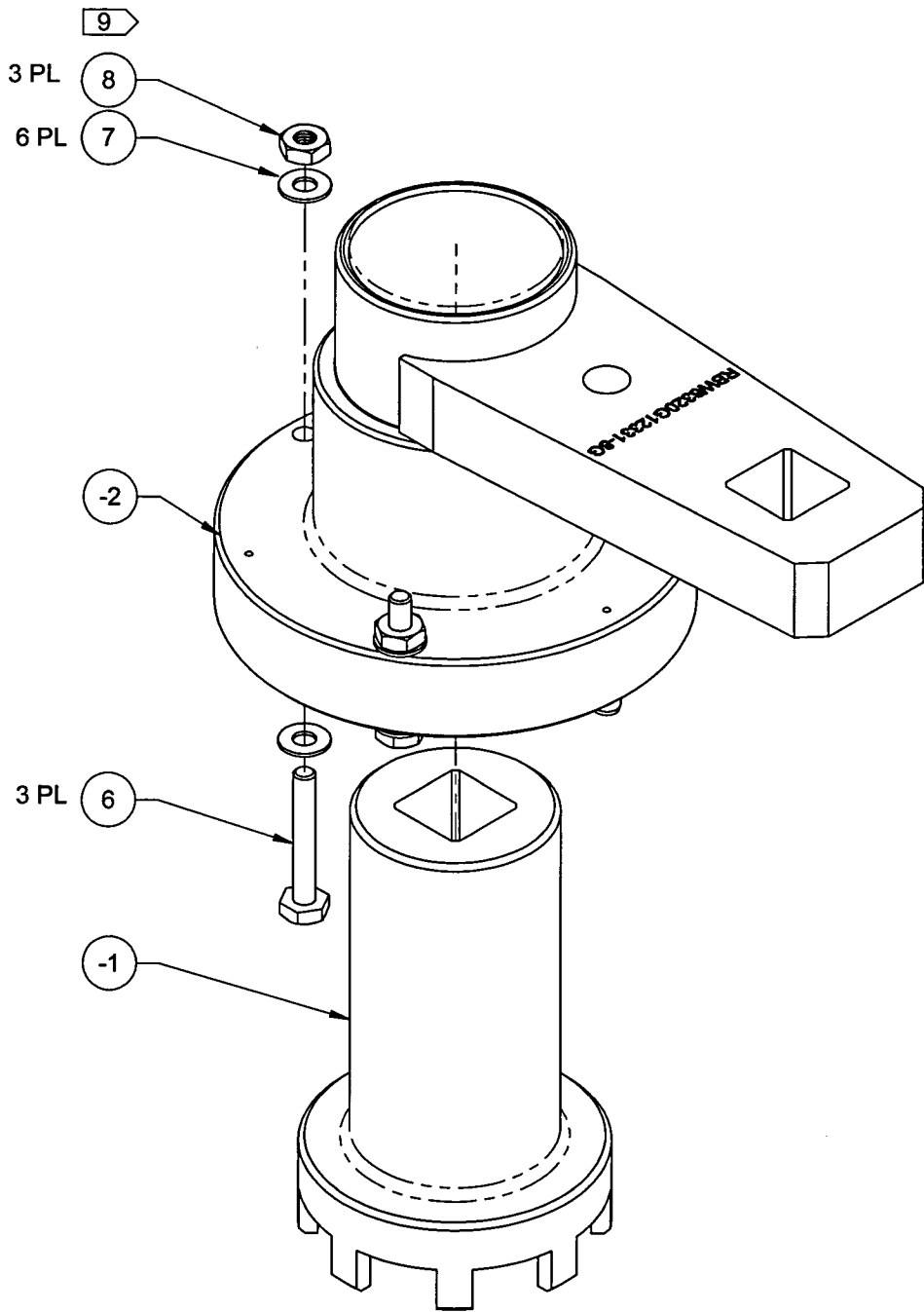


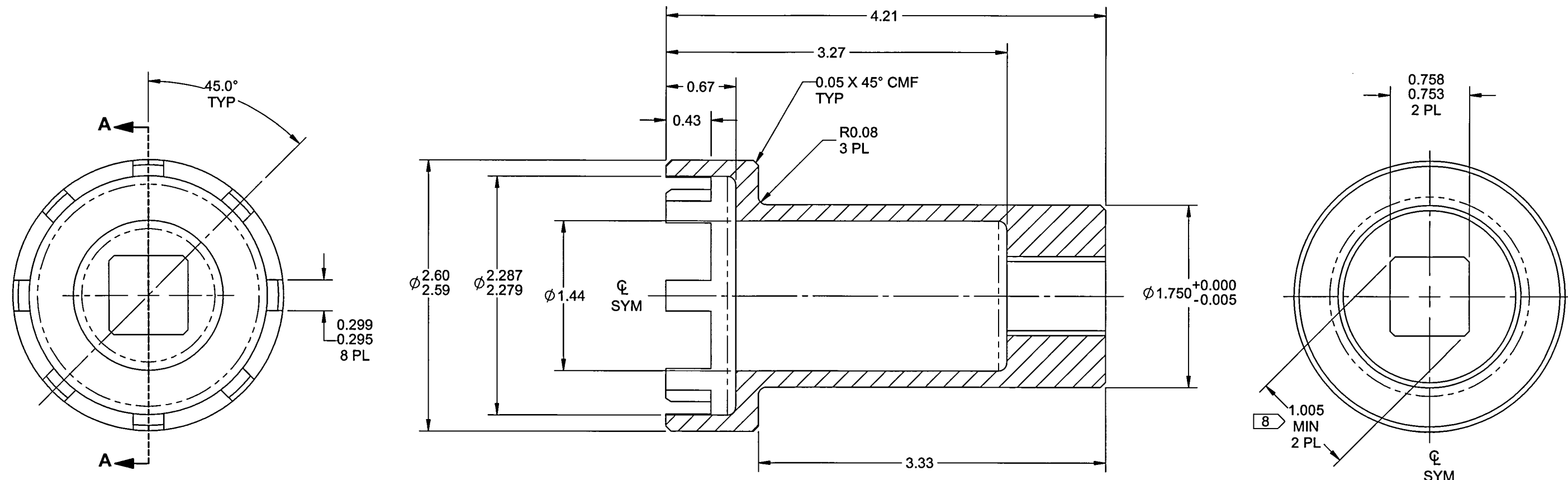
ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6320G12331-8G-1	WRENCH
-2	1	RBW6320G12331-8G-2	REACTION WELDING ASSY
6	3	AN3-12A	BOLT #10-32
7	6	NAS1149F0332P	WASHER #10 x 1/32" THK
8	3	AN315-3R	HEX NUT #10-32



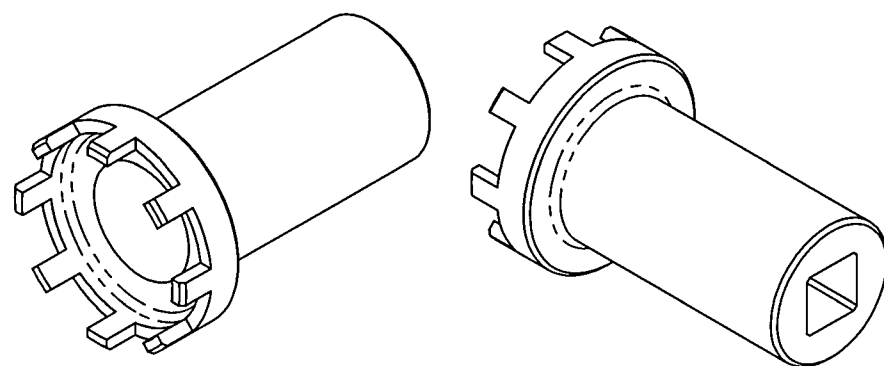
RBW6320G12331-8G MGB INPUT PINION RING NUT REMOVAL / INSTALLATION WRENCH

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN,
 - 9) INSTALL ITEMS 8 HAND TIGHT
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	18-551	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6320G12331-8G	SHEET 1 OF 6
APPROVED	VM	TITLE	SCALE
		MGB INPUT PINION RING NUT REMOVAL / INSTALLATION WRENCH	NTS
DATE	8/28/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A

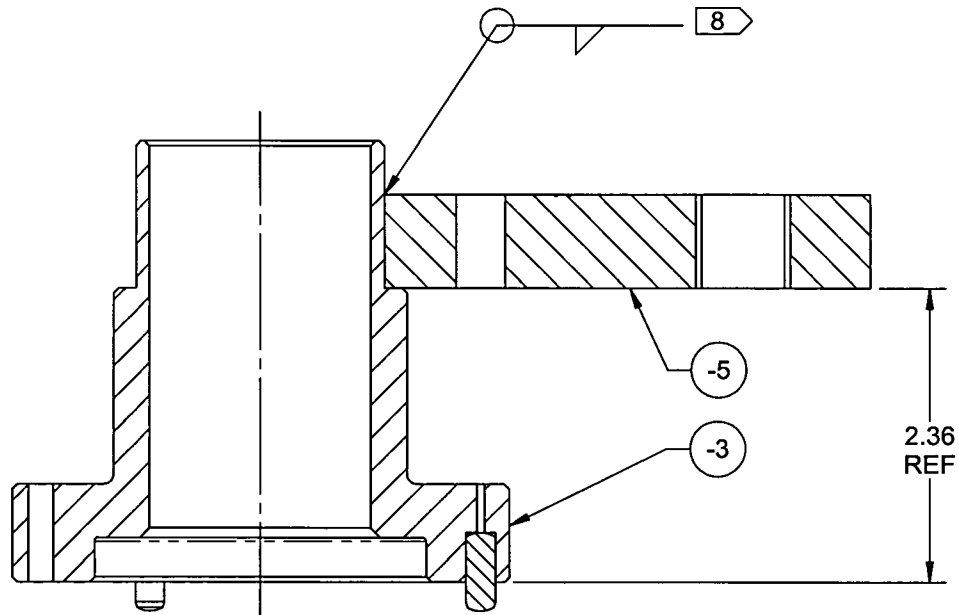
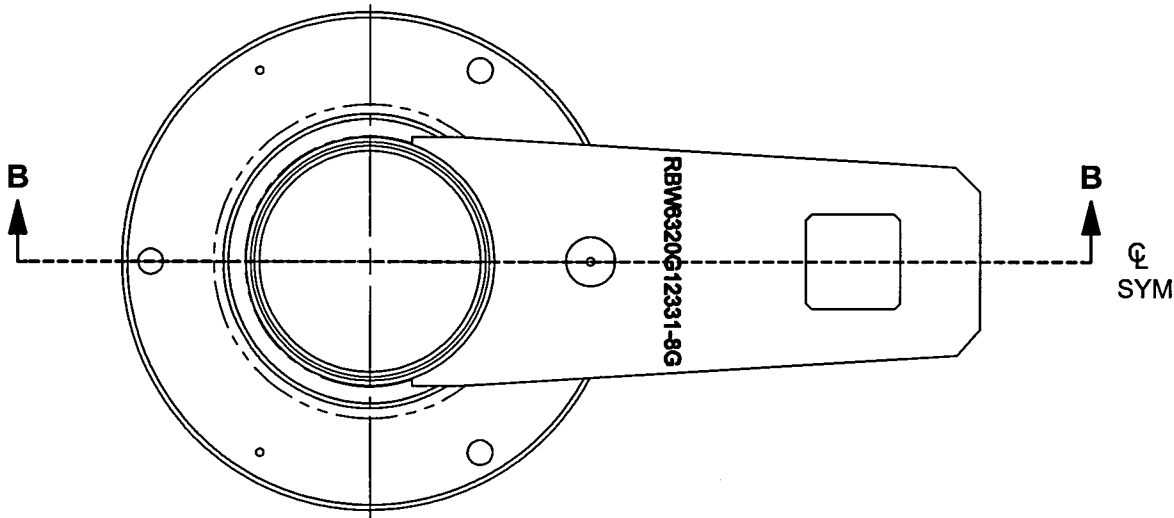


RBW6320G12331-8G-1 WRENCH

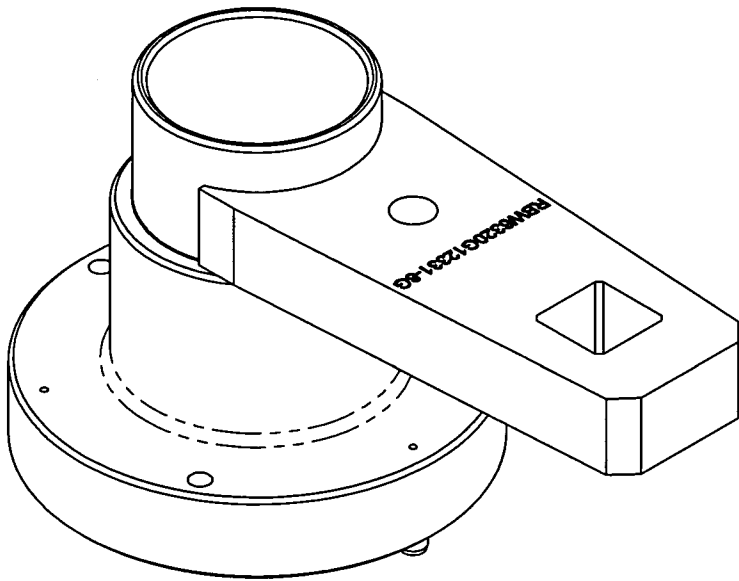
- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 Rc)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6320G12331-8G	SHEET 2 OF 6
APPROVED	VP	TITLE	SCALE
DATE 8/28/2018		MGB INPUT PINION RING NUT REMOVAL / INSTALLATION WRENCH	NTS
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ITEM #	QTY	PART #	PART TITLE
-3	1	RBW6320G12331-8G-3	REACTION ASSY
-5	1	RBW6320G12331-8G-5	REACTION PLATE



SECTION B-B

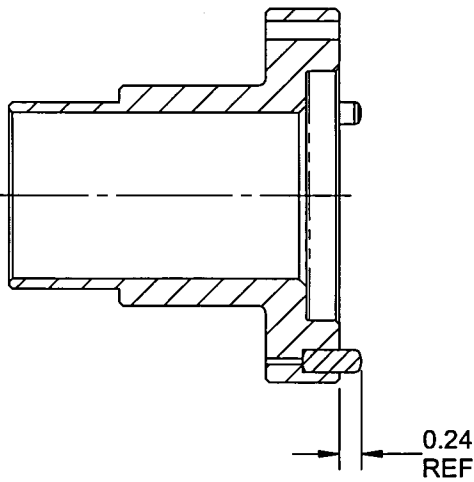
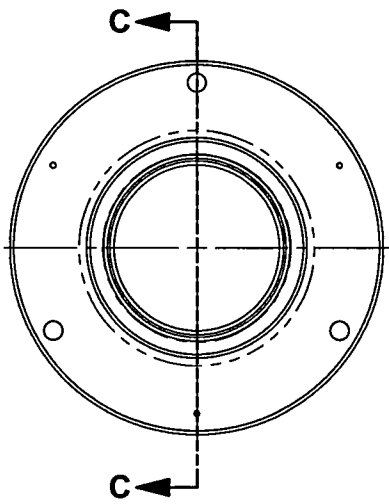
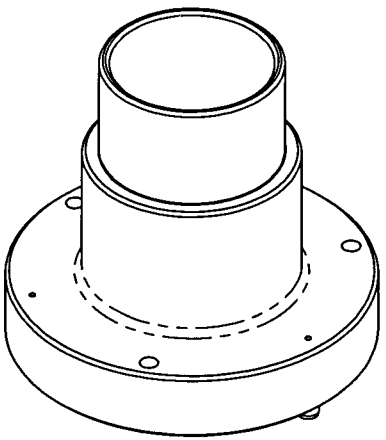
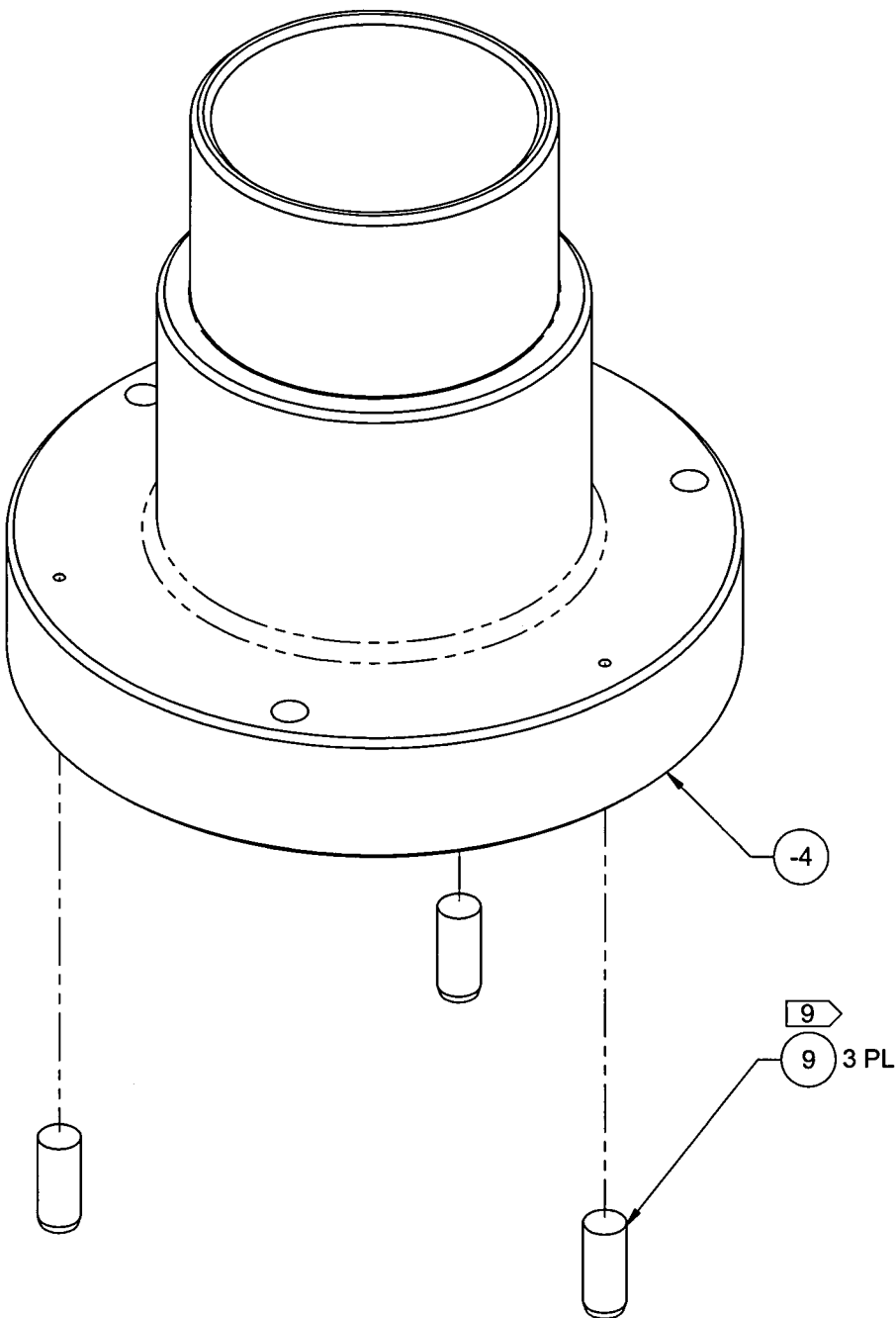


RBW6320G12331-8G-2 REACTION WELDING ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN, ITEMS 3- & -5 MUST BE POSITIONNED AS SHOWN PRIOR TO WELDING

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6320G12331-8G	SHEET 3 OF 6
APPROVED	VP	TITLE	SCALE
DATE 8/28/2018		MGB INPUT PINION RING NUT REMOVAL / INSTALLATION WRENCH	NTS
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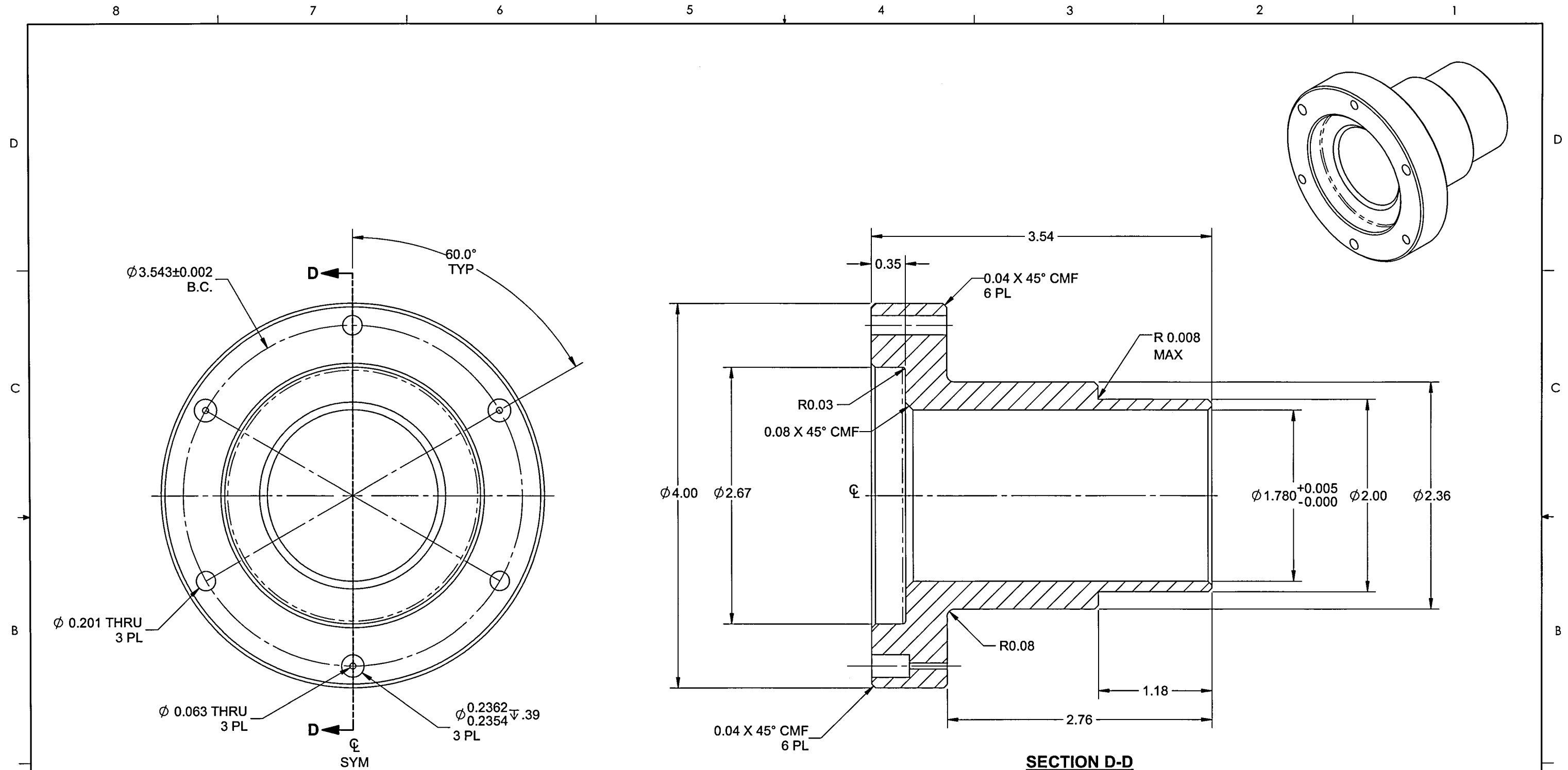
ITEM #	QTY	PART #	PART TITLE
-4	1	RBW6320G12331-8G-4	REACTION
9	3	McMaster#91595A446 OR EQUIV.	STEEL DOWEL PIN 6mm OD x 16mm LG.



RBW6320G12331-8G-3 REACTION ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 9 WITH ITEM -4 AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6320G12331-8G	SHEET 4 OF 6
APPROVED	VM	TITLE	SCALE
DATE 8/28/2018		MGB INPUT PINION RING NUT REMOVAL / INSTALLATION WRENCH	NTS
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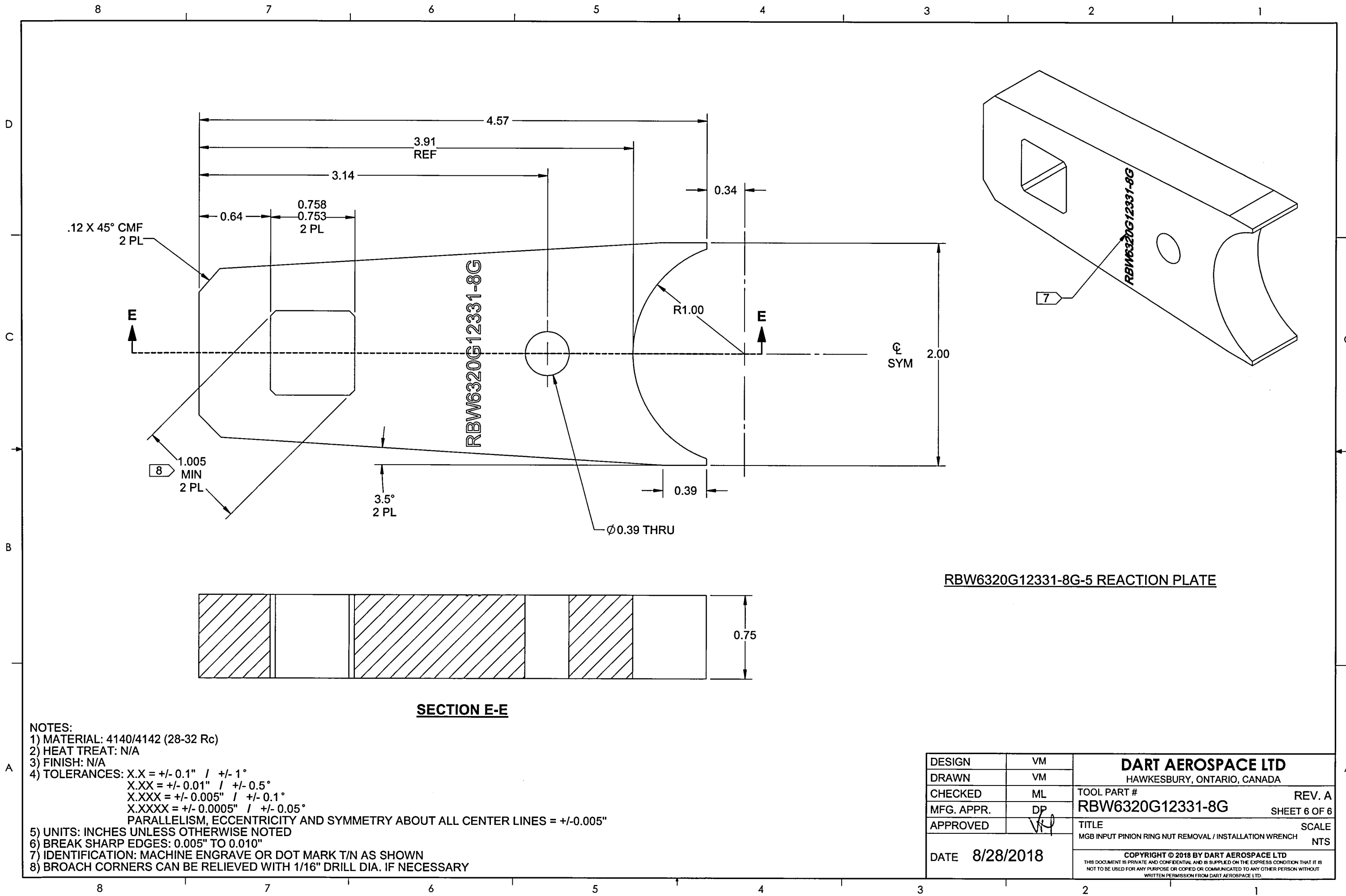
SECTION D-D

RBW6320G12331-8G-4 REACTION

NOTES:

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 Rc)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6320G12331-8G	SHEET 5 OF 6
APPROVED	VM	TITLE	SCALE
DATE 8/28/2018		MGB INPUT PINION RING NUT REMOVAL / INSTALLATION WRENCH	NTS
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RBW6320G12331-8G-5 REACTION PLATE

NOTES:
1) MATERIAL: 4140/4142 (28-32 Rc)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6320G12331-8G	SHEET 6 OF 6
APPROVED	VP	TITLE	SCALE
DATE 8/28/2018		MGB INPUT PINION RING NUT REMOVAL / INSTALLATION WRENCH	NTS
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